

Date: Tuesday, 01/04/2008 3:48:10 PM  
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUAL CARGO MIRROR ASS'Y  
Job Number : 38287  
Estimate Number : 13191  
P.O. Number : Part Number : D119696043  
This Issue : 01/04/2008 S.O. No. : Drawing Number : D3074  
Prsht Rev. : NC Project Number : N/A  
First Issue : 11 Type : SMALL /MED FAB Drawing Revision : *A2*  
Previous Run : 37598 Material :  
Written By : Due Date : 08/04/2008 Qty: 4 Um: Each  
Checked & Approved By : *JD 08-4-01*  
Comment : Est Rev:A 08-02-19 New issue DD verified by: LL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 3.4997 f(s)/Unit Total : 13.9986 f(s)  
304 RD Tube .500 x .035W  
Material: AISI 304/316 SS tube Ø 0.50 x 0.035" wall

Batch *M107403 SB 08/04/03* (6)

2.0 D2054 Bushing - Delrin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing - Delrin  
batch *B31219*

*SB 08/04/03* (6)

3.0 D2055 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Clamp  
batch *B34365*

*SB 08/04/03* (6)

4.0 D2056 Bell Crank Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bell Crank Assembly  
batch *B37625*

*SB 08/04/03* (6)

5.0 D30721 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bracket  
batch *B34635*

*SB 08/04/03* (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DUAL CARGO MIRROR ASS'Y

Job Number: 38287

Part Number: D119696043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30722

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket

batch

B 36636

SB 08/04/03 (6)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- punch one side

2- slide parts in tube

3- punch other side

4- bend as per dwg D3074

5- drill holes as per dwg D3074

6- deburr and polish

SB 08/04/03

FF 08-04-03 (6)

FF 08-04-04 (6)

FF 08-04-07 (6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/04/07 (6)

9.0

D2011101

Mirror 6"



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mirror 6"

batch

37326

1/x

B 38288x1 FF 08-04-09 (6)

10.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

batch

M106552

34 x

M1675342 x

SB 08/4/07 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 38287

Part Number: D119696043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

batch

M106242

*[Handwritten signature]*

12.0

MS27039118

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

batch

M106112

*[Handwritten signature]* 8/1/7 (6)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3074

FF 08-04-08 (6)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/02 (46)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 38284

*[Handwritten signature]* 8/4/9 (6)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/14 *[Handwritten signature]*

Job Completion



MF 08-04-10

*[Handwritten signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

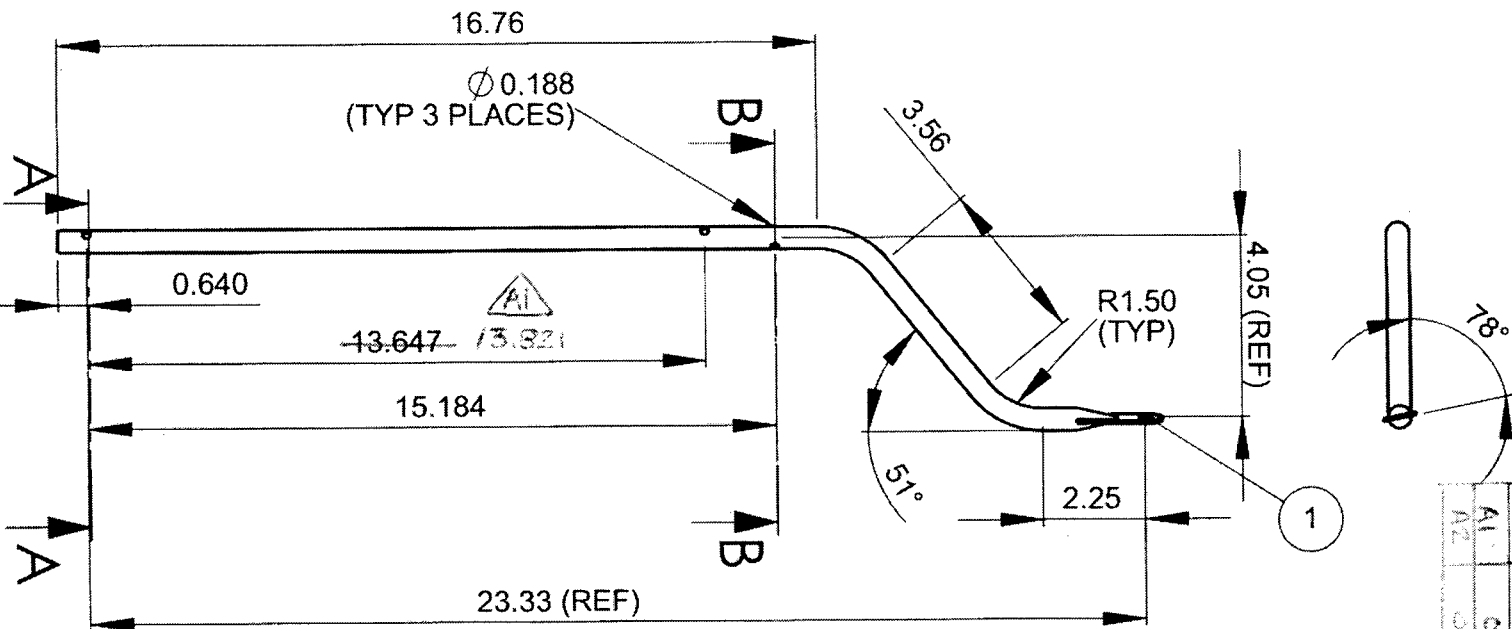
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

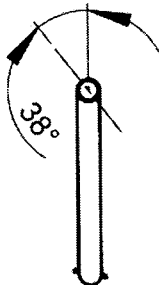
**DART**



DESIGN	✓	DRAWN BY	✓	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	APPROVED	✓	DRAWING NO.	D3074
DATE	01.12.17	TITLE	ARM	REV. A	SHEET 1 OF 2
A	01.12.17	NEW ISSUE		SCALE	1:4
AI	02.04.15	15.821 WAS 13.647	✓		
AZ	02.03.22	ADD FINISH	✓		



SECTION A-A  
(TYP 2 PLACES)



SECTION B-B  
(1 PLACE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 332887

**D3074-1**

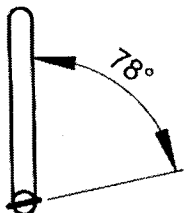
- 1) PUNCH END PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\varnothing 0.50 \times 0.035$  WALL  
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

5) FINISH: POWDER COAT BLACK SANJTEX (4.35.7) PER DART QSI 018 43 AZ

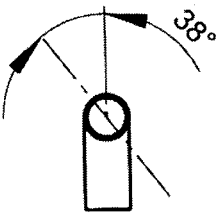
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02.01.15

**DART**

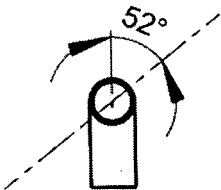
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>	REV. A
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 2
DATE	TITLE	DRAWING NO.	SCALE
01.12.17	ARM	D3074	1:4



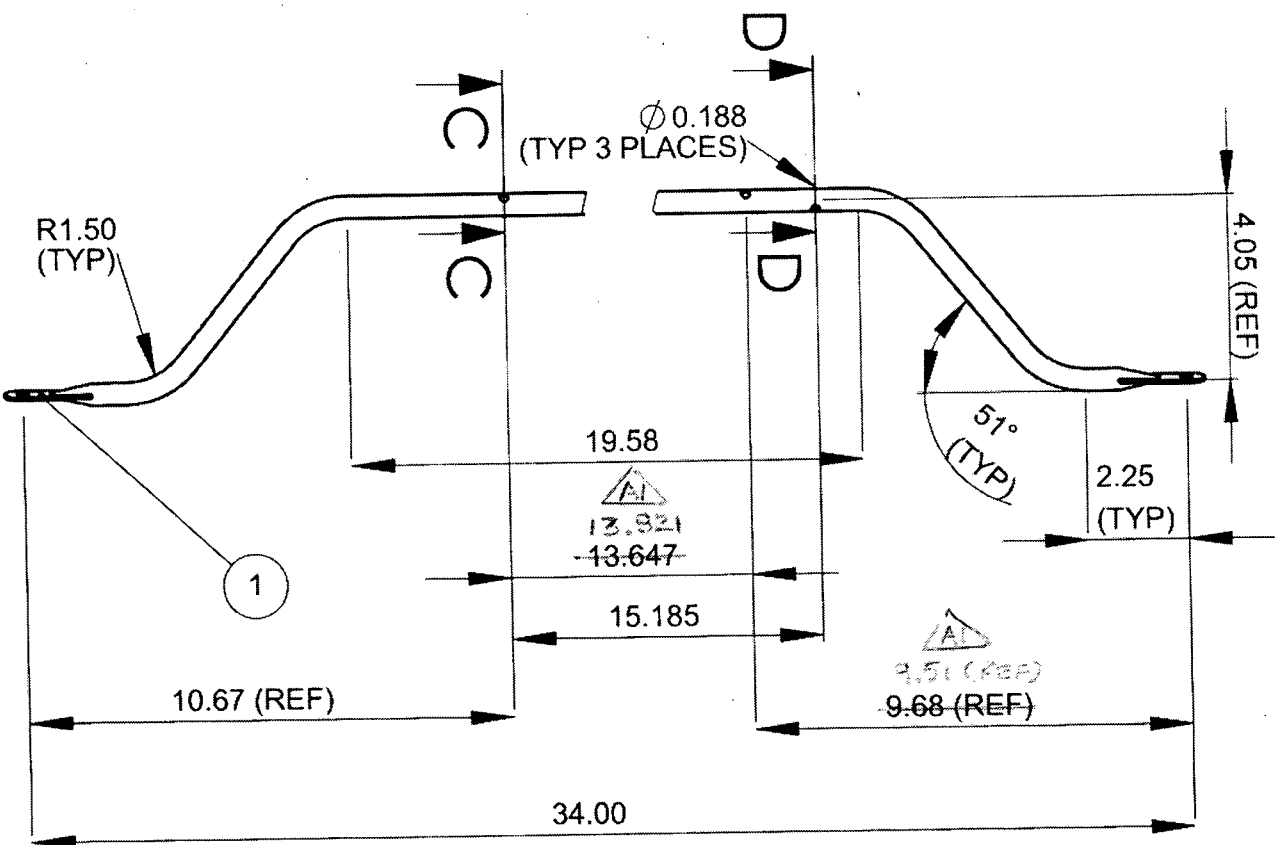
RELEASED  
02.01.15



SECTION D-D (1:2)  
(1 PLACE)



SECTION C-C (1:2)  
(TYP 2 PLACES)



**D3074-3**

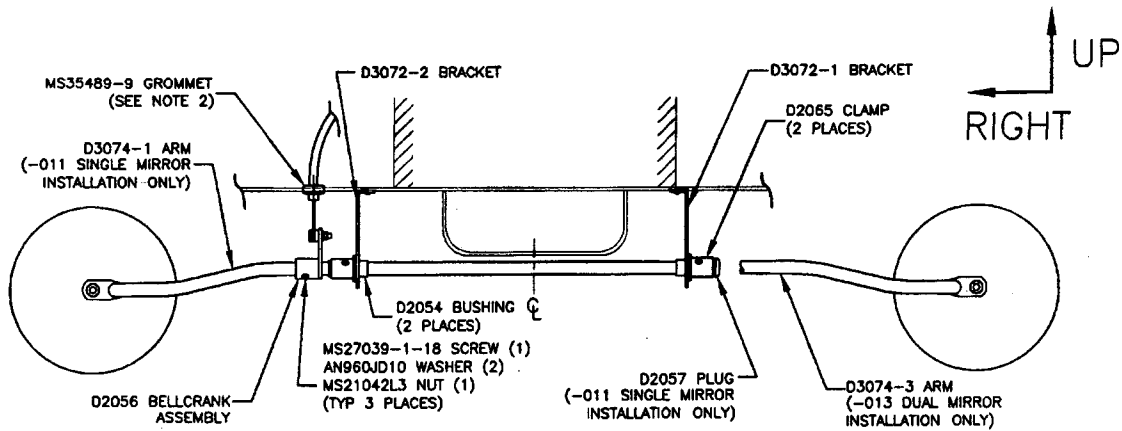
- 1) PUNCH ENDS PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\varnothing 0.50 \times 0.035$  WALL  
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS NOT SYMMETRIC

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WITHOUT NOTICE  
WORK ORDER  
No. 238287

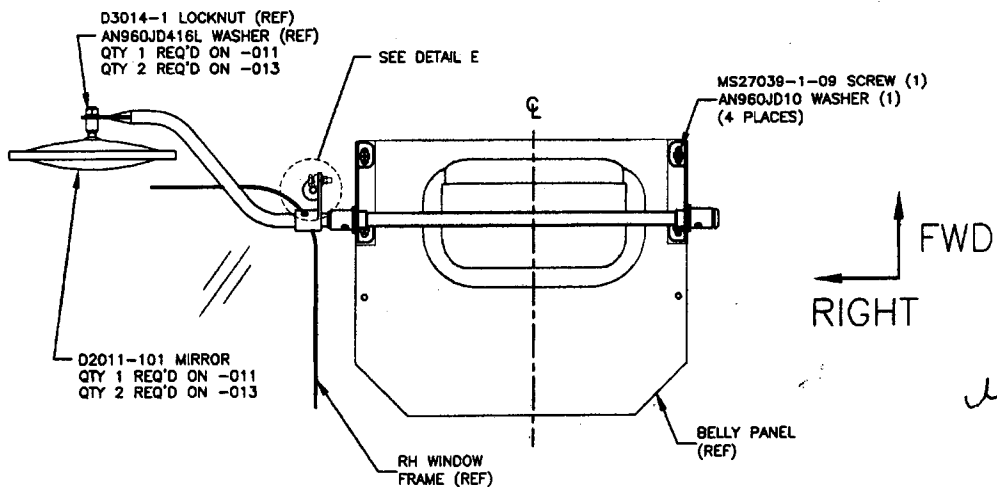
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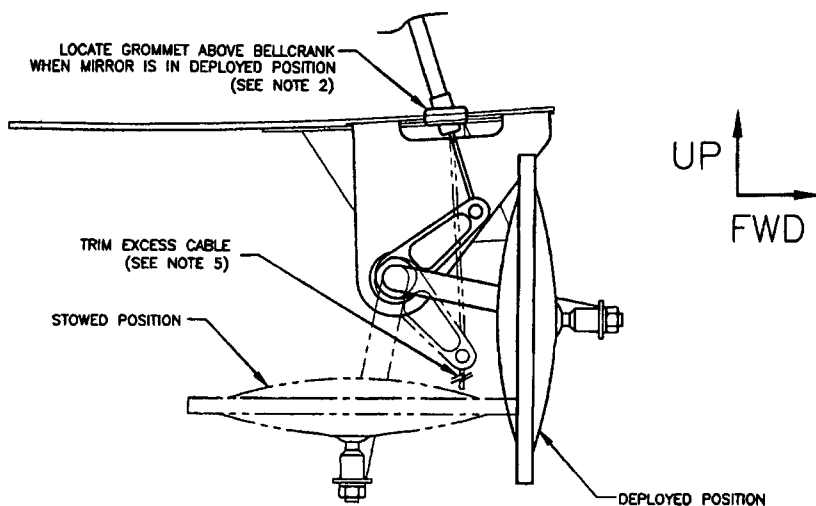
**Figure 25-2 – View A: Looking Aft**  
(D119-696-011/-013 Mirror Shown)



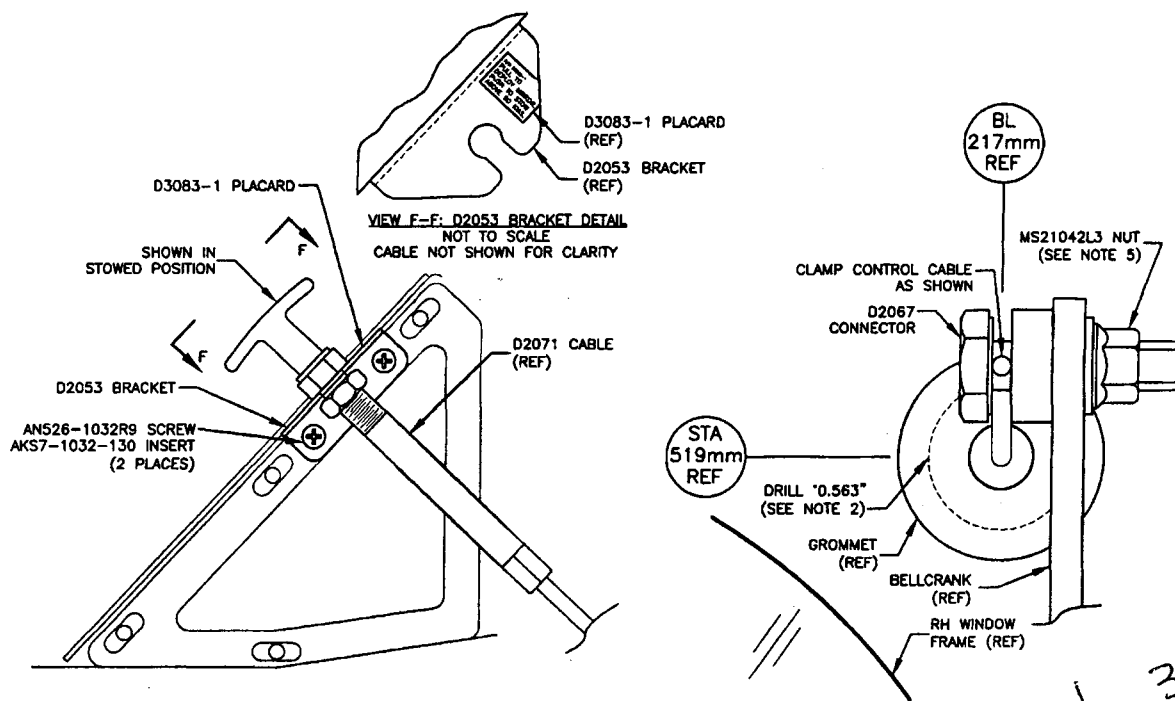
**Figure 25-3 – View B: Looking Up**  
(D119-696-011 Mirror Shown, -013 similar)

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**25-00-00**



**Figure 25-4 – Detail C: Side View of Mirror Deployment**  
(D119-696-011/-013 Mirror Shown)



**Figure 25-5 – Detail D**  
**Control Panel Attachment**  
(D119-696-011/-013 Mirror Shown)

**Figure 25-6 – Detail E**  
**Bellcrank/Cable Attachment**  
(D119-696-011/-013 Mirror Shown)

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**25-00-00**